

## **IN THE SPECIFICATION:**

Please amend the specification as follows:

Please replace the paragraph beginning at page 3, line 9 through page 3, line 27 with the following rewritten paragraph.

The method according to the invention is preferably ~~realised~~ realized in a machining installation also according to the invention. Such a machining installation serves for machining of wood workpieces, squared timbers, boards and the like, in a feeding region a first conveying system for the wood workpiece being provided, which approaches fed wood workpieces to a machining aggregate, and on the discharge side of the machining aggregate a second conveying system being provided, and the machining aggregate, if necessary, machines on the front end region of the wood workpiece. The invention is ~~characterised~~ characterized by the fact that the first and/or second conveying system conveys the wood workpiece for further machinings of the machining aggregate. According to the invention it is planned that an overlapping of the machining and the conveying movement is carried out. By means of that it is basically possible to carry paths, respectively to use also the axis of movement of the workpiece during the machining. This becomes even more comfortable and varied by another moved axis with the workpieces.

Please replace the paragraphs beginning at page 4, line 8 through page 5, line 22 with the following rewritten paragraphs.

In particular the invention aims at only one machining aggregate in the machining installation. This does, however, not mean that the invention is not ~~realised~~ realized in machining installations with several machining aggregates. In such an application case it has to be taken into consideration that in particular also the first machining aggregate does not only carry out a machining of the front end region of the wood workpiece, but it can also carry out other machinings. In this respect the performance according to the invention is used with the first machining aggregate and thus the advantage according to the invention is reached.

The special advantage of the invention is ~~emphasised~~ emphasized of course if only one machining aggregate is used which is, also a part of the invention, also, if necessary, equipped also complex, in order to allow a number of different machinings.

In a preferred embodiment of the invention it is provided that the positioning system, respectively a measuring equipment connected with it, is ~~normalised~~ normalized during the first machining of the wood workpiece by the machining aggregate, for example the clipping, to the respective position of the conveying system to the wood workpiece. By means of this development according to the

invention the exact position of the conveying system, that means its working point on the wood workpiece, is not important. The machining installation, respectively the measuring equipment of the positioning system of the conveying system, knows the respective position of the conveying system with regard to the location of the first machining, making an exact further positioning of the wood workpiece possible without any problems. The ~~normalisation~~ normalization here acts as ~~initialisation~~ initialization of the measuring equipment in order to make sure that a correspondingly exact machining is carried out. This indexing or ~~initialisation~~ initialization does not require the use of a clipping cut at the front end of the wood workpiece. This ~~initialisation~~ initialization is carried out, for example, optically (light barrier or light curtain), mechanically or electrically (respectively capacitively) in the same way and thus sets the measuring equipment to zero for the ~~normalisation~~ normalization. The indexing, respectively the ~~initialisation~~ initialization, requires of course that the wood workpiece be ~~recognised~~ recognized first of all, respectively collected. If necessary simultaneously not only the positioning systems of both conveying systems are ~~normalised~~ normalized but they are also ~~synchronised~~ synchronized to each other.

Alternatively it is suggested that the conveying system conveys the wood workpiece before a machining towards a stopper and thus the respective position of the conveying system to the wood workpiece is ~~normalised~~ normalized. In this case

the control knows to which the method according to the invention is applied, respectively the machining installation itself the position of the stopper with regard to the location of the machining point and thus carries out a ~~normalisation~~ normalization, respectively an ~~initialisation~~ initialization. This procedure as well leads to an exact and reliable machining.

It is convenient if first of all the first conveying system conveys the wood workpiece for the machining to the machining aggregate, respectively the stopper, and if there the ~~initialisation~~ initialization, respectively the ~~normalisation~~ normalization, starts. As the machining installations are designed in such a way that both conveying systems are ~~normalised~~ normalized to each other accordingly, in particular when a passing of the wood workpiece from the first to the second conveying system is carried out, it is also advantageous if a corresponding ~~initialisation~~ initialization is also carried out for the conveying system which is not directly involved with the approach of the wood workpiece.

Please replace the paragraph beginning at page 6, line through page 6, line with the following rewritten paragraph.

In a preferred embodiment a supporting beam is provided which also carries the driving roller, respectively wheel or cylinder. In this example the supporting

beam also takes over the driving motor for the driving roller. Such an embodiment allows in the case of repair a quick replacement action of this structural component. Another advantage, however, is the fact that the supporting beam is supported seesawing or rotatable, in particular ~~centred~~ centered around an axis horizontally or even rectangular orientated to the conveying direction. By means of that it is guaranteed that the conveying unit, respectively the driving roller always sits, safely and reliably, close to it, even when the thickness of the workpieces are different.

Please replace the paragraph beginning at page 9, line 17 through page 9, line 27 with the following rewritten paragraph.

If several tools are used there is a possibility in that to ~~realise~~ realize for each tool its own axis of movement with the corresponding drives. Another possibility is to mount, for example, the tools which engage in opposition (that is above and below with regard to the wood workpieces) together to a frame embracing the wood workpiece and to move this frame by a drive. Such an arrangement saves a separate drive of the tools. Such a design is particularly advantageous when not only two tools should be used but a third and fourth one at the respective sides of the wood workpiece. By means of that the axes of movement are used double.

Please replace the paragraph beginning at page 12, line 38 through page 13, line 2 with the following rewritten paragraph.

It is an advantage if at least one, preferably both conveying system(s) have a positioning system with a corresponding measuring equipment. Of course, the positioning system here comprises the possibility to convey the wood workpiece 3 as well as means for ~~recognising~~ recognizing that the desired position has been taken. Usually this is achieved by means of a corresponding ~~normalisation~~ normalization or ~~initialisation~~ initialization at the beginning of the workings and a path measuring, determining the relative position of the positioning system with regard to the indexing point, initiation point or ~~normalisation~~ normalization point and making by means of that also the position of the wood workpiece 3 on the means of that also the position of the wood workpiece 3 on the machining installation exactly definable. It is, for example, provided that the measuring equipment is formed by measuring wheel 11 which rolls off on the wood workpiece. This means that the measuring wheel is a part of the measuring equipment belonging to the first conveying system 1.

Please replace the paragraph beginning at page 13, line 29 through page 13, line 32 with the following rewritten paragraph.

In particular in the second conveying system 2 the measuring equipment is ~~realised~~ realized in the guide line 21, respectively in the coupling unit 20, and sufficiently known from the state of the art.

Please replace the paragraphs beginning at page 15, line 47 through page 16, line 32 with the following rewritten paragraphs.

A wood workpiece 3 is put on the machining installation in the supplying region 90. The wood workpiece 3 is gripped by the first conveying system 1 and conveyed into the machining aggregate 4. The first conveying system 1 has a measuring equipment, the measuring wheel 11 which is part of it comes into engagement with the wood workpiece 3 and defines the suitable position. The wood workpiece 3 is now, for example, indexed (for example by a light barrier or the like) or conveyed to a cross saw in order to be clipped. At this point it is an advantage if the positioning system of either the first or the second or of both conveying systems is ~~normalised~~ normalized, respectively ~~initialised~~ initialized, as now a defined position of the wood workpiece 3 in the machining aggregate 4 is available.

Contrary to the state of the art now there is the possibility that the machining aggregate carries out additional machinings on the wood workpiece. The machining aggregate 4 may have here only one tool 41 which has, if necessary, carried out the

clipping cut. Conveniently, however, the machining aggregate 4 has a plurality of different tools in order to make accordingly complex machinings possible. It is convenient here that the different tools can move along several translator axes (which shall form, if possible, a Cartesian system), and, if possible, even longitudinal machinings can be carried out while using the conveying movement of the wood workpiece. The machining installation is ~~optimised~~ optimized in such a way that either the first conveying system 1 or the second conveying system 2 or both conveying systems together perform a movement and guide of the wood workpiece through the machining aggregate. The higher the number of different tools in the machining aggregate 4, the more complex machinings are possible and the shorter is the construction of the machining installation compared with corresponding machining installations with the same functions according to the state of the art, because with these every further tool group was arranged in an independent machining aggregate, in a separated place from another machining step.

Please replace the paragraph beginning at page 17, line 4 through page 17, line 12 with the following rewritten paragraph.

On the discharge side 91 a supporting table 92 is shown which is located considerably below the tongs parts 25. Furthermore supports 202 are shown which



can be lowered (double arrow 203). The supports 202 can be removed, which causes the wood workpiece to fall down so far that the movement of the coupling element 20 is not obstructed. The ~~stops~~ supports 202 are here designed in such a way that they can be lowered, however, they can also be removed to the side in order to achieve the same result.

Please replace the paragraph beginning at page 17, line 48 through page 18, line 22 with the following rewritten paragraph.

In a variant of the invention it has been found that it is an advantage if the bearing cross conveyer conveys the wood workpiece to a stopper or a stopper rail, and the first conveying system is arranged in the direction of conveying of the bearing cross conveyer before the stopper, respectively the stopper rail, and the first conveying system conveys a wood workpiece further as soon as it has contact with the stopper/stopper rail. A roller conveyor in the conveying direction of the conveying system is not necessary here. Such an arrangement is, for example, an advantage with comparatively light wood workpieces, like single boards and so on. The occurring friction force does not lead to a blocking of the conveying system. The advantage of such an arrangement is the fact that the feeding of the next wood workpieces is carried out continuously and not, first of all, a pulling-in device has to

be brought in position which has to grip the wood workpiece, convey it inside, swivel it away and position it again. For example, the bearing cross conveyer approaches the wood workpieces continuously and a removed wood workpieces already releases the stopper rail, respectively the stopper, in order to bring the next, second wood workpiece in position. The speed of such a machining installation increases accordingly. It is an aspect of the invention to design the machining installation as time ~~optimised~~ optimized as possible, that means to save in each machining step machining times, non-load movements and so on, in order to reach a machining as quick as possible.